Work Order ID 66132

Monday, February 07, 2011 10:56:29 AM

Item ID: D2618
Revision ID:
Item Name: Bushing
Start Date: 2/8/2011 **Start Qty:** 80.00
Required Date: 2/22/2011 **Req'd Qty:** 80.00
Reference:

Accept

Setup Start
Stop

Cust Item ID:
Customer:

Approvals: **Process Plan:** MF **Date:** 11-02-07 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start
Stop

Draw Nbr	Revision Nbr
D2618	Rev B1

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 Hardinge Hardinge CNC Lathe Small	Hardinge CNC LATHE SMALL **Memo** 1-Turn as per Folio FA195 & Dwg D2618.□2-Deburr	0.00 0.00			11.2.10	80			
110 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00			11.2.10	80			
120 QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00			B.A 11/02/14	80	ø		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run **Start**
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: 019	0.00							
Packaging									
Packaging	**Memo**	0.00							
140	QC21- Final Inspection - Work Order Release	0.00							
QC									
Quality Control	**Memo**	0.00							

11/02/14 FO

CK 11/02/15

MF 11-02-15

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Picklist Print

Monday, February 07, 2011 10:56:26 AM

Work Order ID: 66132

Parent Item: D2618

Parent Item Name: Bushing

Start Date: 2/8/2011 **Required Date:** 2/22/2011

Start Qty: 80.00 **Required Qty:** 80.00

Comments: IPP Rev:F Re-format 05-11-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR0.750 Delrin Round Bar 0.75"		Purchased	No			100	f	84.7470	0.258	21.72632 11-2-10			

Location		Loc Qty	Loc Code
MAT		34.3	
	116183	34.3	20.669
MAT050		50.447	
	112418	0.12	
	115472	50.327	

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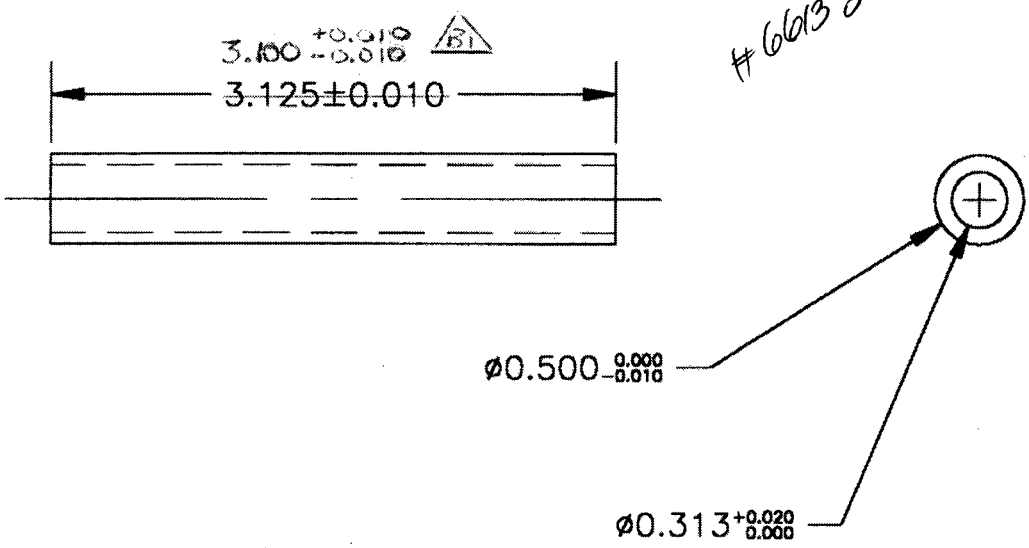
DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
BW	KE		
CHECKED	APPROVED	DRAWING NO.	REV. B
BW	BW	D2618	SHEET 1 OF 1
DATE		TITLE	SCALE
96:10:30		BUSHING	1:1
B	97.05.09	3.125 WAS 1.625, .313 WAS .375	
B1	04.06.03	CHANGE DIM FOR BETTER FIT	

DART

QA COPY ISSUED

RELEASED 97/05/13 DS

#6613 2



MATERIAL: DELRIN OR TEFLON OR NYLON

4.573

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Dart Aerospace Ltd

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NOTE: Date & initial all entries

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DART AEROSPACE LTD	Work Order:	66132
Description: Bushing	Part Number:	D2618
Inspection Dwg: D2618 **Rev:** B1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.100	+/-0.010	3.105	✓		RQ-02	
Ø0.500	+0.000/-0.010	.495	✓			
Ø0.313	+0.020/-0.000	.320	✓			

Measured by:		Audited by:	B.A	Prototype Approval:	N/A
Date:	11.2.10	Date:	11/02/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.26	New Issue	KJ/JLM	
B	04.09.10	Changed tolerance for Ø0.500	KJ/JLM	

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